

Work Order ID 71183

Thursday, June 23, 2011 11:16:44 AM



Page 1

Item ID: D3755-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Cushion

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3753

Rev D

D3755

Rev C

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

14369

Manufacture D3753-1 cushion as per dwg Dwg D3753

Upholster as per Dwg D3755

Supplier: Aerotex

Material release note is required

CL 11/06/24 (4)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Rec'd 7/3 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71183

Thursday, June 23, 2011 11:16:44 AM



Page 2

Item ID: D3755-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Cushion

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/10/07

(24)

Quality Control

130

Identify as per dwg & Stock Location 252A

0.00



Packaging

Memo

0.00

11/7/08 SL (4)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/7/11

ME

11-07-08

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:16:42 AM

Page 1

Work Order ID: 71183



Parent Item: D3755-041



Parent Item Name: Seat Cushion


Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A08.11.17 New issue EC verified by:DD IPP Rev:B
10.04.13 as per ECN10-539 Verified by:EC IPP Rev:C 10.05.03
remove velcro per comment (W/O 58260) DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3755-041P  Seat Cushion		Purchased	No			110	Each	0.0000	1	4			



Signature (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

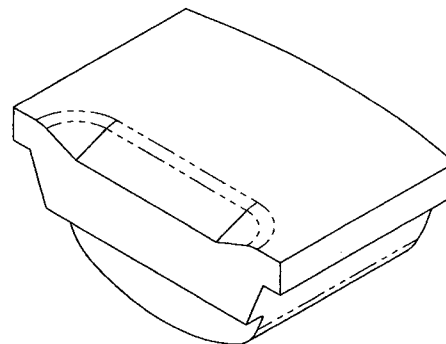
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -1	PART NUMBER	DESCRIPTION
1	X		D3755-041	CUSHION
2	1	X	D3755-1	COVER
3	1		D3753-1	SEAT FOAM
4		2	LOOP STRIP, 2"	3M SJ3418FR, 2" WIDE BEIGE OR D3800-1-200-100
5	A/R		LOOP STRIP, 1"	3M SJ3418FR, 1" WIDE BEIGE OR D3800-1-100-400
6		A/R	HOOK STRIP, 1"	APLIX 800, A800R0025H958-1, 1" WIDE BEIGE OR D3800-3-100-400
7		A/R	FABRIC	JACKSON GREY MIX
8		A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR
9	A/R		ADHESIVE	3M 1300 / 1300L RUBBER AND GASKET ADHESIVE OR SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
10		A/R	ZIPPER	PACANNA BRASS AUTOLOCK ZIPPER #5



D3755-041 CUSHION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71183
CL11/06/23

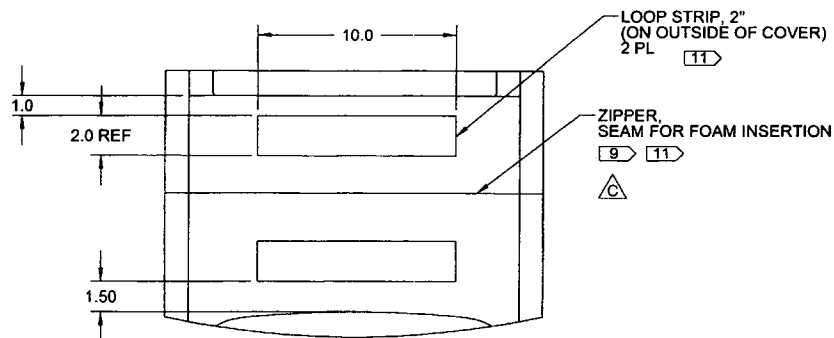
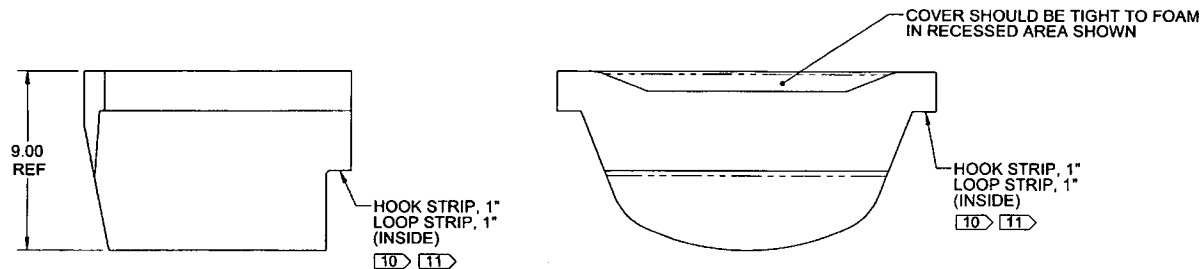
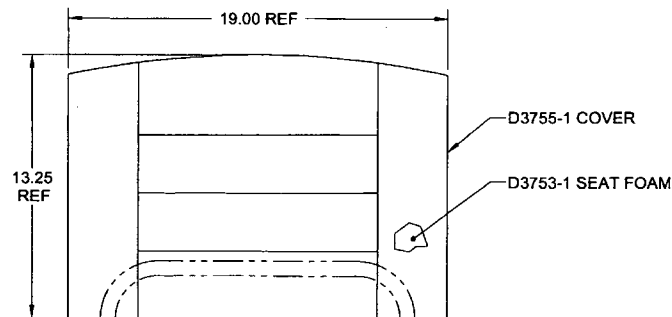
RELEASED
2010-03-23
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3755-041" USING LABEL
- 7) WEIGHT: 3.3 lbs APPROX
- 8) SEW D3755-1 COVER TO FIT D3753-1 FOAM
- 9) STITCH ZIPPER ALONG EDGE OF SEAM TO CLOSE COVER
- 10) TO PULL FABRIC AGAINST FOAM IN CONCAVE AREAS, STITCH HOOK STRIP (1") TO INSIDE OF COVER AS REQ'D.
BOND LOOP STRIP (1") TO FOAM.
- 11) STITCHING: 4-6 STITCHES PER INCH, USE MIN 1/2" BACKSTITCH, NO LOOSE THREADS
- 12) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9419
- 13) ANY REQUIRED BONDING SHOULD BE DONE WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE

C	UPDATE TO VIEWS/NOTES DUE TO D3753 BEING RESHAPED & NEW MFR. FABRIC, HOOK, LOOP, ADHESIVE CHG (D5-1), ADD ZIPPER (D5-1, B4-2). REF PAR 09-030.	CP	10.02.02
B	COVER NOW CLOSED WITH SINGLE SEAM (ZN A8-1, B3-2). D3800-1-100-300 WAS D3800-1-100-800 (D8-1). D3800-3- 100-300 WAS D3800-3-100-800 (D8-1). ORIENTATION OF D3800-1-200-000 CHANGED (B3-2), ADD ITEM NUMBERS TO PART LIST (D8-1)	CP	08.10.21
A	NEW ISSUE	CP	08.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.02.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3755	REV. C
TITLE CUSHION	SCALE NTS
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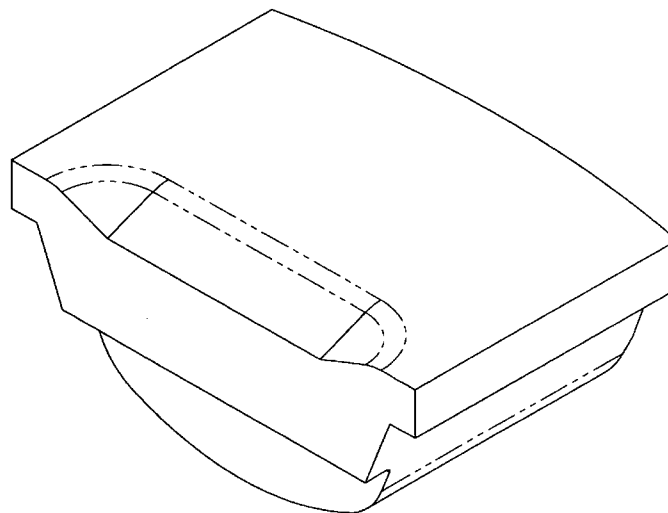


D3755-041 SEAT CUSHION

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2010-03-23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3755	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION	NTS
DATE	10.02.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY



D3753-1 SEAT FOAM

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2010-03-23
wp

NOTES:

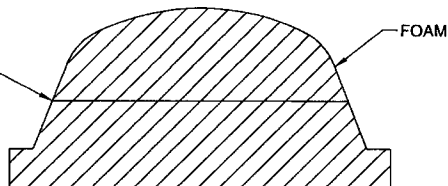
- 1) MATERIAL:
FOAM = FOAMEX H270-40S1 FOAM
OR
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING GRADE 40-50 (COLOR: LIGHT YELLOW)
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 503330-99
ADHESIVE = BOND FOAM LAYERS (IF REQUIRED) WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3753-1" USING PERMANENT MARKER
- 7) WEIGHT: 3.3 lbs APPROX
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9027

D	RE-SHAPED TO IMPROVE COMFORT PER PAR 09-030. ADD FOAMEX & 3M 1300 MAT'L (ZN A8-1)	CP	10.02.02
C	CHG SHAPE TO MATCH CHESTNUT SAMPLE: 5.69 WAS 5.85 (B8-2), 4.00 WAS 4.25 (B3-2), 1.25 WAS 1.00 (B3-2)	CP	08.10.08
B	FOAM SHORTER TO AVOID CYCLIC, 12.25 WAS 16.75 (C7- 2), 5.85 WAS 6.88 (B8-2), FRONT PROFILE CHANGED (B3-2)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.02		

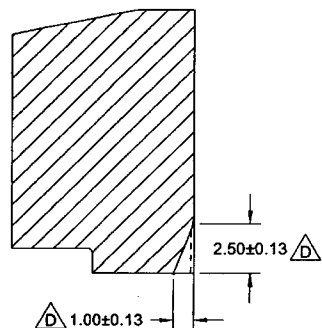
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3753	REV. D SHEET 1 OF 2
TITLE SEAT FOAM	SCALE NTS
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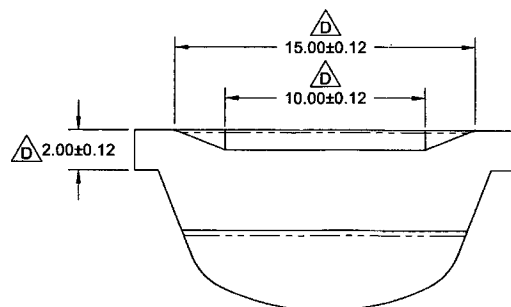
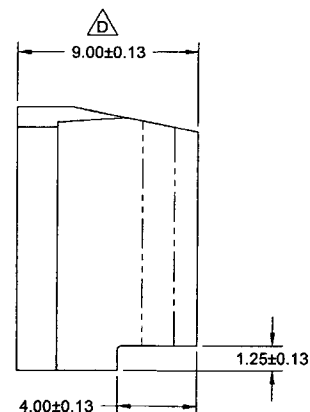
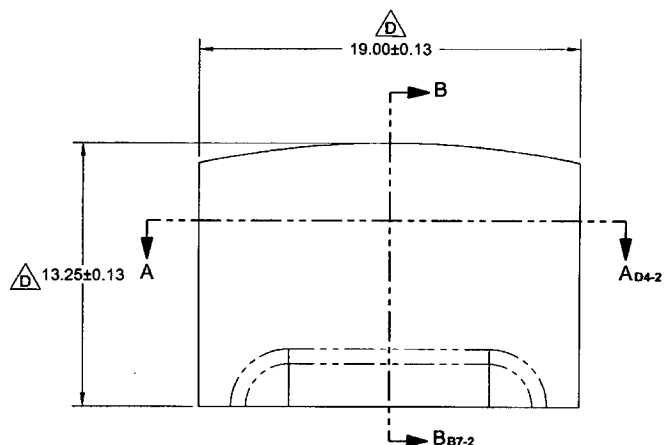
BOND FOAM LAYERS (IF PRESENT)
WITH SILAPRENE DC12906
OR 3M 1300/1300L ADHESIVE



SECTION A-A C4-2



SECTION B-B B5-2



D3753-1 SEAT FOAM

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2010-03-23
MP

DESIGN	<i>GP</i>	DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO. D3753	REV. D
MFG. APPR.	<i>GP</i>	SHEET 2 OF 2	
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	SEAT FOAM	NTS
DATE	10.02.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SALES SPECIFICATION


FOAM GRADE: H270-40SJ / UC 45
COLOR: PEACH

EFFECTIVE: 01-12-04
SUPERSEDES: 02-13-01

TEST ITEM	UNIT	RANGE	TEST METHOD
DENSITY	PCF	2.56-2.83	ASTM 3574
I.F.D. @ 4" THICK			
- 25% DEFLECTION	LBS.	37.0—43.0	ASTM 3574
- 65% DEFLECTION	LBS.	95.0 MIN.	ASTM 3574
SUPPORT FACTOR	RATIO	2.50 MIN.	
RECOVERY	%	80 MIN.	
HYSTERESIS LOSS	%	20 MAX	
CONSTANT DEFLECTION			
COMPRESSION SET			
- 90% DEFLECTION	%	10 MAX.	ASTM 3574
- 75% DEFLECTION	%	8 MAX.	ASTM 3574
- 50% DEFLECTION	%	3 MAX.	ASTM 3574
STEAM AUTOCLAVE AGING			
- COMPRESSION SET @			
50% DEFLECTION	%	N/A	ASTM 3574
DRY HEAT AGING			
- COMPRESSION SET @			
50% DEFLECTION	%	5 MAX.	ASTM 3574
AIR FLOW	CFM	1.0 MIN.	ASTM 1564
RESILIENCE (BALL TEST)	%	50.0 MIN.	ASTM 3574
TENSION TEST			
- TENSILE STRENGTH	PSI	15.0 MIN.	ASTM 3574
- ULTIMATE ELONGATION			
GRIP SEPARATION	%	100 MIN.	ASTM 3574
TEAR RESISTANCE	PLI	1.20 MIN.	ASTM 3574
STATIC FATIGUE 75%			
- I. F. D. LOSS @ 25%	%	10 MAX.	ASTM 3574
- THICKNESS LOSS			
@ 75% COMPRESSION	%	1 MAX.	ASTM 3574
FLAMMABILITY PERFORMANCE *			
- CALIFORNIA TECHNICAL BULLETIN 117, SEC. A, PART I	PASS		
- CALIFORNIA TECHNICAL BULLETIN 117, SEC. D, PART II	PASS		
- FEDERAL M.V.S.S. 302	PASS		
- FAA, FAR 25.853 (B)	MEETS		

* THIS FLAMMABILITY DATA IS NOT INTENDED TO REFLECT HAZARDS PRESENTED BY THIS OR ANY OTHER MATERIAL UNDER ACTUAL FIRE CONDITIONS.

NOTE: FAA, FAR 25.853 (B) MUST BE TESTED EACH RUN BY A INDEPENDENT CERTIFIED LAB TO CERTIFY FOR USE ON AIRCRAFT. THIS MATERIAL HAS BEEN TESTED AND MEETS THIS STANDARD.

The above specifications have been reviewed and approved.  S. Carpenter Plant Manager October 14, 2002



24 - 2333-18 Avenue NE
Calgary, AB T2E 8T6
PH: 403.295.8770 FX: 403.313.0793
EM: info@aerotex.ca WS: www.aerotex.ca

Packing Slip

Date Packing Slip#

27/06/2011 8135

Ship: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Bill: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone
613.632.5200

Customer Fax
613.632.1053

Email: PURO ACCT 1-7684382

Ship Via
FedEx P1

Courier Acct No.
1517-9324-0

Ship Date P.O. No.

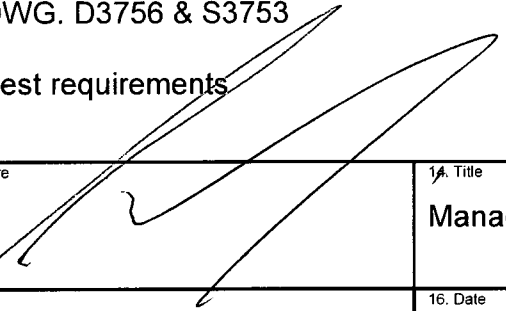
27/06/2011 14369

Aircraft	Description	Part Number	Qty
DART	SEAT CUSHION	D3755-041P	4
DART	BACK CUSHION	D3756-041P	4
	GST On Sales		

Thank you for doing business with Aerotex Interiors!

GST/HST No. 139110308

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1. Organization issuing certificate. Aerotex Interiors Inc., 24 – 2333 18 Ave NE Calgary, AB T2E 8T6		2. CERTIFICATE OF CONFORMANCE			3. Work Order / Contract / Invoice 8135
4. Customer Name DART Aerospace Ltd					5. Customer Purchase Order 14369
6. Item	7. Description	8. Part No./Specification	9. Qty.	10. Batch No.	11. Status
1	1" Velcro Loop – Beige	D3800-1-100-700	NA	5049	NEW
2	1" Velcro Loop – Beige	D3800-3-100-700	NA	5049	NEW
3	2" Velcro Loop – Beige	D3800-1-200-600	NA	5049	NEW
4	Fabric	Jackson Greymix	NA	9	NEW
5	Thread - Bonded Polyester Grey	14.2lb Break Strength	NA	NA	NEW
6	Adhesive	3M 1300/1300L Adhesive	NA	NA	NEW
7	Foam	H250-35S1	NA	5304	NEW
8	Foam	H270-40S1	NA	5304	NEW
12. Remarks I certify that the materials supplied for the Purchase/Repair Order listed above conform to Aerotex Interiors's material/process specification and are in all respects in conformance with the contract requirements. I further certify that the materials meets and complies with DWG. D3756 & S3753 Burn test requirements					
13. Signature 		14. Title Manager			
15. Name Carson Chanthvong		16. Date June 27, 2011			